

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012429**Date Inspected:** 01-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 7AW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG033A-004. The welder is identified as #054467 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-repair for WR10697 UT repair.

Segment 7AE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG034A-007. The welder is identified as #048659 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-repair for CWR1211 UT repair.

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Segment 6AE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as FB030-001-128. The welder is identified as #220066 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair-1 for WR10680 UT repair.

This QA Inspector observed grinding at the ends of Deck Plate stiffeners at the Cross Beam Connection between panel points 38-40.

Segment 6CW/7AW

This QA Inspector observed removal of fit up plates along the Side Plate CJP segment splice by flame cutting.

Segment 6CE

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) after weld repair on the Longitudinal Diaphragm flange to Floor beam connection panel point 47 east, cross beam and bike path side.

Lift 5 East

This QA Inspector observed grit blasting in progress on the interior components.

Segment 6CW

This QA Inspector observed grinding of weld profile on fillet welds of Partial Height Diaphragm at panel points 45, 46, exterior FL3 location.

Segment 7CE

This QA Inspector observed ABF personnel performing UT on the Deck Plate to Edge Plate CJP splice, bike path side. D scan was performed.

ZPMC Quality Control (QC) Inspector is identified as Wang Li Wang. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for

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your project.

Inspected By: Hernandez,Dan

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer